

# Work Order ID 100200

April-19-13 9:09:18 AM

\*100200\*

Page 1

Item ID: D350-591-214

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step. Short RH

Start Date: 4/19/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M65

Date: 1304-19 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3078	A								
DSI 9472	A								
100	DOCUMENT CONTROL	0.00							
*100*									
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-214 CHG003								
110	Large Fab	0.00							
*110*									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets. 3-Deburr								

DAS 06 9-13 1304-19

①

M65 13-06-19

①

φ

Ac 13.05.22

April-19-13 9:09:18 AM

Page 2

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									DAS 19 8-89 13-06-18
130		0.00							
<b>*130*</b>	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078 A/RAluminum Rod 125127 3-Grind End Plate flush 123928								
									13-06-18
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									DAS 09 8-89 13-06-18

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\*100200\*

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Item ID: D350-591-214

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step. Short RH

Start Date: 4/19/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

\*150\*

QC

Quality Control

Memo

0.00

13-06-13

DAS  
09  
9-89

160	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

\*160\*

HandFinish

Hand Finishing

Memo

0.00

13-06-13

13-06-18

170	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

\*170\*

QC

Quality Control

Memo

0.00

13-06-18

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Item ID: D350-591-214

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Heli-Access-Step. Short RH

Start Date: 4/19/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Large Fab	0.00							
*200*									
Large Fab	Memo	0.00							
Large Fab	1- Rivet Leg Assembly as per Dwg D3078.								13-06-18
	2-Bevel Aft end for welding								
	3-Inspect for foreign object as per QSI 024								
	4-Weld Aft End Plate as per QSI 004 & Dwg D3078								
	A/R Aluminum Rod 125127								
	5-Grind End Plate flush								
210	QC10- Inspect visual per QSI004- ground welds	0.00							
*210*									
QC	Memo	0.00							
Quality Control									

① B-06-19

DAS  
09  
2-89

Work Order ID 100200

April-19-13 9:09:18 AM

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Item ID: D350-591-214

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Heli-Access-Step. Short RH

Start Date: 4/19/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00							
*220*									
QC	Memo	0.00							
Quality Control									

① B-06-19

045  
09  
8-89

230	Chemical Conversion Coat per QSI005 4.1	0.00							
*230*									
HandFinish	Memo	0.00							
Hand Finishing									

1 7/13-6-19

240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*240*									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 9:20  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 9:50

1 X 2 m / 13/06/19

M125620

April-19-13 9:09:18 AM

\*100200\*

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 4/19/13      **Start Qty:** 1.00      **\*1\***

Cust Item ID:

**Required Date:** 5/03/13      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250 Wing Walk as per dwg QSI005 4.4 Batch 125887 0.00

**\*250\***

HandFinish

## Memo

0.00

## Hand Finishing

260 QC3- Inspect Part Finish

0.00 *AS*

**\*260\***

QC

## Memo

0.00 13.619

## Quality Control

270 Pick Kit

0.00

**\*270\***

### Packaging

## Memo

0.00

### Packaging

SP  
B-6-19  
~~2~~

# Work Order ID 100200

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\*100200\*

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Item ID: D350-591-214

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step. Short RH

Start Date: 4/19/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 *280* QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							
290 *290* Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D350-591-214 Location: <u>860</u> PPP Rev: _____	0.00  0.00							
300 *300* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

DAS  
06  
4-83

13/6/19

13-6-19

13-06-20

130620

# Picklist Print

April-19-13 9:09:24 AM

Page 1

8

Work Order ID: 100200

\*100200\*

Parent Item: D350-591-214

\*D350-591-214\*

Parent Item Name: Heli-Access-Step. Short RH

Start Date: 4/19/13

Required Date: 5/03/13

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19 Added D2732-030 AS PER DS19294 JLM

IPP Rev:C 06-06-27 Revised as per DS19340 JLM IPP Rev:D

10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			110	Each	123.9700	0.5	0.5			

\*D2622-120C\*

Step Extrusion

\*\*

13.05.22

### Location

### Loc Qty

### Loc Code

WA003

123.97

75781

0.5

81507

4

89750

10.47

93552

3

98024

106

0.5

D3063-1

Manufactured No

130

Each

47.0000

1

1

\*D3063-1\*

Support

\*\*

13.06.18

### Location

### Loc Qty

### Loc Code

WA003

47

71886

7

95754

40

1



# Picklist Print

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Page 2

Work Order ID: 100200

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

\*100200\*

\*D350-591-214\*

Start Date: 4/19/13

Required Date: 5/03/13

Start Qty: 1.00

Required Qty: 1.00

D3067-1

Manufactured No

130

Each

257.0000

1

1

\*D3067-1\*

End Plate

\*\*

B95170 → ① 13.05.22

## Location

## Loc Qty

## Loc Code

WA

78

95515

5

98655

73

WA003

79

67582

2

68214

1

78608

4

79607

1

83855

1

90178

1

90486

3

95170

64

95930

102

D3066-1

Manufactured No

200

Each

51.0000

2

2

\*D3066-1\*

Spacer

\*\*

B99840 → ② 13.05.22

## Location

## Loc Qty

## Loc Code

WA003

51

95963

11

98003

40

MS20600-AD4W4

Purchased No

200

Each

350.0000

16

16

\*MS20600-AD4W4\*

Rivets

\*\*

M120406 → ① 13.05.22  
M125654 → ② 13.05.22

## Location

## Loc Qty

## Loc Code

ST311

350

123900

350

April-19-13 9:09:24 AM

Shop Packet Print

Page 2

# Picklist Print

April-19-13 9:09:24 AM

Work Order ID: 100200

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step. Short RH

\*100200\*

\*D350-591-214\*

Start Date: 4/19/13

Required Date: 5/03/13

Start Qty: 1.00

Required Qty: 1.00

D3065-041

Manufactured No

200

Each

65.0000

1

1

\*D3065-041\*

Step Leg Assembly Hi

\*\*

*AK 13.05.13*

## Location

## Loc Qty

## Loc Code

WA003

65

79336

1

96158

24

97928

40

(1)

D3067-1

Manufactured No

200

Each

257.0000

1

1

\*D3067-1\*

End Plate

\*\*

*AK 13.06.18*

## Location

## Loc Qty

## Loc Code

WA

78

95515

15

98655

73

WA003

179

67582

12

68214

11

78608

14

79607

11

83855

11

90178

1

90486

3

95170

64

95930

102

# Picklist Print

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Page 4

Work Order ID: 100200

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step. Short RH

\*100200\*

\*D350-591-214\*

Start Date: 4/19/13

Required Date: 5/03/13

Start Qty: 1.00

Required Qty: 1.00

AN4-16A

Purchased

No

270

Each

103.0000

**\*AN4-16A\***

Bolt

**\*\* 4 4**

*Sp* *Sp*

Location

Loc Qty

Loc Code

FG

5

121541

5

ST357

98

124215

98

270

f

399.8962

**\*\* 1**

*4x* *1*

*Sp*

D2732

Manufactured

No

**\*D2732\***

Rubber Extrusion

*3x 3x per kit*  
*4x 3x*

Location

Loc Qty

Loc Code

ST410

399.8962052

70987

0.3

83560

3.5962052

94725

396

*1x*

Cut 3.00" long, qty 4

AN3-35A

Purchased

No

270

Each

493.0000

**\*AN3-35A\***

Bolt

**\*\* 2 2**

*Sp B-6-19*

Location

Loc Qty

Loc Code

FG

10

122800

10

ST352

483

125211

483

*2x*

# Picklist Print

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Page 5

Work Order ID: 100200

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step. Short RH

\*100200\*

\*D350-591-214\*

Start Date: 4/19/13

Required Date: 5/03/13

Start Qty: 1.00

Required Qty: 1.00

AN4-11A

Purchased

No

270

Each

187.0000

\*AN4-11A\*  
Bolt

\*\*

2

SP

SP

Location

Loc Qty

Loc Code

FG

20

120731

20

ST514

50

123900

50

ST517

17

124221

17

270

Each

0.0000

AN960JD416

NAS1149D0463J

Purchased

No

\*AN960JD416\*

Washer

D2230-3

Manufactured

No

270

Each

508.0000

\*D2230-3\*

Lug

\*\*

12

12

M/24778 SP

\*\*

2

2

SP 13-6-19

Location

Loc Qty

Loc Code

FG

4

89045

4

ST469

504

89782

19

90514

1

94957

4

96117

7

97815

393

97903

80

# Picklist Print

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Page 6

Work Order ID: 100200

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

\*100200\*

\*D350-591-214\*

Start Date: 4/19/13

Required Date: 5/03/13

Start Qty: 1.00

Required Qty: 1.00

D2856-400

Manufactured No

270 f

324.6839

\*D2856-400\*-720

Abrasion Strip

0.6 0.6

\*\*

SP

## Location

## Loc Qty

## Loc Code

ST408	211.15
99378	211.15
ST410	38.5
95159	38.5
ST415	75.0339
63735	0.6696
68076	0.3149
71164	8.46
81875	6.398
86905	0.9569
89352	24.6745
90764	33.56

0.6

cut 7.20" long, qty 1

MS21042L3

Purchased

No

270

Each

4,717.000

\*MS21042L3\*

Nut

2 2

\*\*

SP 13-6-19

## Location

## Loc Qty

## Loc Code

FP001	3
122141	3
GA	110
122452	110
ST314	268
117885	32
119017	55
119075	138
123265	43
ST506	4336
123900	974
124291	3362

2x

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Shop Packet Print

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# Picklist Print

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Page 7

Work Order ID: 100200

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step. Short RH

\*100200\*

\*D350-591-214\*

Start Date: 4/19/13

Required Date: 5/03/13

Start Qty: 1.00

Required Qty: 1.00

AN4-13A

Purchased

No

270

Each

311.0000

\*\*

4

\*AN4-13A\*

Bolt

SP

m12538f SP

SP

Location

Loc Qty

Loc Code

FG

20

122808

20

Return2012

8

122416

8

ST514

283

122993

13

123900

10

124221

260

270

Each

221.0000

\*\*

2

D2230-1

Manufactured

No

\*D2230-1\*

Lug

SP

SP

SP

Location

Loc Qty

Loc Code

FG

4

84136

4

ST469

217

89783

16

95217

120

96247

41

97814

40

270

Each

1,507.000

\*\*

6

MS21042L4

Purchased

No

\*MS21042L4\*

Nut

SP

m125535  
SP 13-6-19

SP

Location

Loc Qty

Loc Code

FP001

318

122452

306

8182

12

ST518

1189

124231

1189

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Shop Packet Print

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Picklist Print

April-19-13 9:09:25 AM

Page 8

Work Order ID: 100200

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

\*100200\*

\*D350-591-214\*

AN960ID10

NAS1149D0363J Purchased

No

270

Each

0.0000

Start Date: 4/19/13

Required Date: 5/03/13

Start Qty: 1.00

Required Qty: 1.00

\*AN960ID10\*

Washer

52

\*\*

m124392 sp

13-6-19.

8



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3078</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, HI SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED  
02.01.10 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

1002001105  
13-04-19

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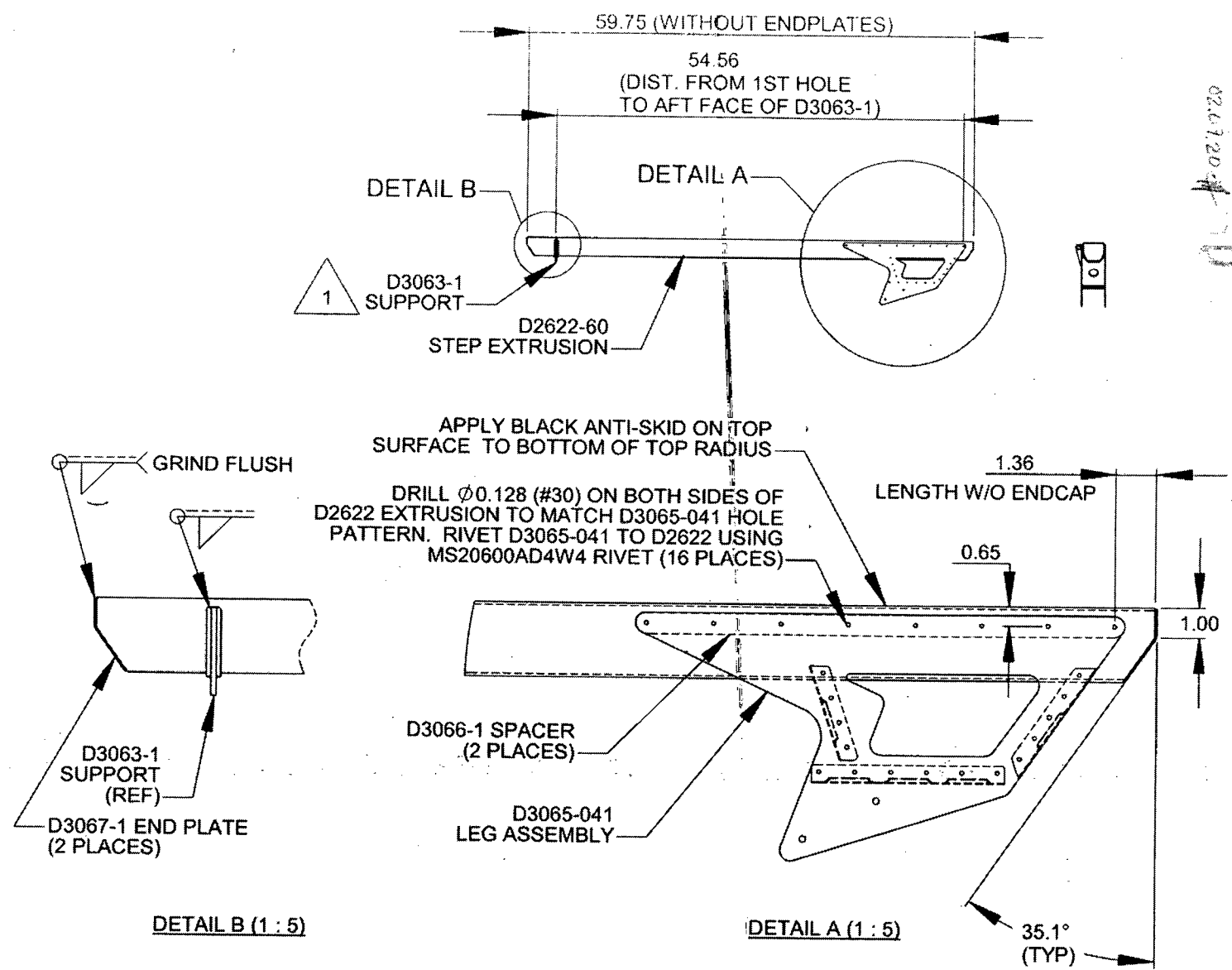


100Zee



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3078	SHEET 2 OF 2
02.09.11		TITLE	SCALE
		STEP ASSEMBLY, HI SHORT	1:20

02.07.2004



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# DART SERVICE INSTRUCTION


TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER  
REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

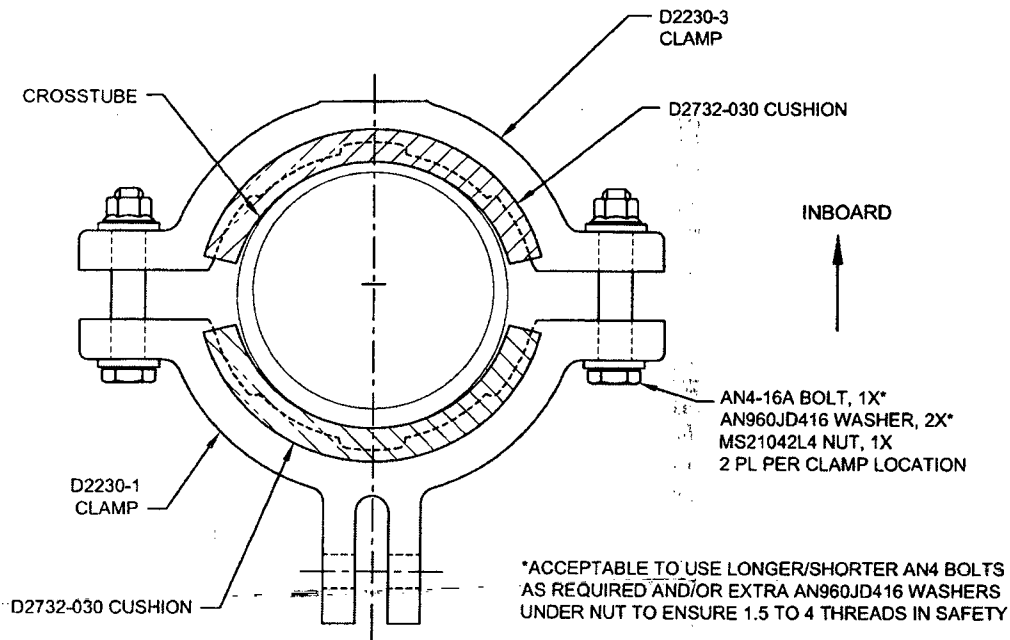
## ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED 
BY: D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. A
CHECKED	RF	DSI 9472	SHEET 1 OF 2
MFG. APPR.	NDA	TITLE	SCALE
APPROVED	NDA	BOLT ADDITION	NTS
DE APPR.	NDA	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DATE	09.08.05	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

1002001



**FIGURE 1: CLAMP DETAIL**  
**OPTIONAL CLAMP CONFIGURATION**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
*[Signature]*

BY: D. SHEPHERD (DE # 02)

DATE: 09.08.05  
CERT. NO.: SH92-6  
ISSUE NO.: 11

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT ADDITION	NTS
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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
								D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
1								D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1							D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1						D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1					D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1				D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1			D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
							1	D2182B035	RUBBER CUSHION
4	4							D2230-1	MOUNTING LUG
		2	2	2	2			D2230-3	MOUNTING LUG
		2	2	2	2	4	4	D2274	RADIUS BLOCK
8	8							D2618	BUSHING
						2	2	D2732-030	CUSHION
4	4	4	4	4	4			D2856-400-720	ABRASION STRIP
2	2	1	1	1	1	2	2	D3064-1	CLAMP
2	2							D3079-041	SUPPORT ASSEMBLY
1	1							D3080-1	CLAMP
4	4							D3235-1	MOUNTING LUG
						2	2	D3278-041	SUPPORT ASSEMBLY
						1	1		
								AN3-35A	BOLT
2	2	2	2	2	2	2	2	AN4-11A	BOLT
10	10	2	2	2	2			AN4-13A	BOLT
		4	4	4	4	8	8	AN5-36A	BOLT
						2	2	AN960JD40	WASHER
4	4	4	4	4	4	4	4	AN960JD416	WASHER
20	20	12	12	12	12	16	16	AN960JD516	WASHER
						4	4	MS21042L3	NUT
2	2	2	2	2	2	2	2	MS21042L4	NUT
10	10	6	6	6	6	8	8	MS21042L5	NUT
						2	2		
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.



13/6/19 SP

REFERENCE 0001

**DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER  
REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

**ADD:**

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

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BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
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A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION		BY
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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